

Work Order ID 103838

103838

Page 1

July-02-13 11:29:02 AM

Item ID: D205-634-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Fits LH or RH

Start Date: 7/02/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 2.00 *2*

Customer:

Reference: rework/repair RETURN FOR REWORK

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI9468	A
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IIN D205-634	G
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100 0.00

100

DC

Memo

0.00

Document Control

B/N 282 & 29580

101 0.00

101

Skidtubes

Memo

0.00

Skidtubes-

STEP 2 ON RS1010

DD
BB 13-7-3



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Item ID: D205-634-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Fits LH or RH

Start Date: 7/02/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 2.00 *2*

Customer:

Reference: rework/repair

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102	QC5- Inspect part completeness to step on W/O	0.00							
102									
QC	Memo	0.00							
Quality Control									
103		0.00							
103									
Skidtubes	Memo	0.00							
Skidtubes	STEP 4 ON RS1010								
104	QC5- Inspect part completeness to step on W/O	0.00							
104									
QC	Memo	0.00							
Quality Control	VERIFY FIT OF SADDLES (FWD/AFT) AND GHW LUGS								

3/10/13

DD 13-7-4

DAS 16 9-83 3/10/14

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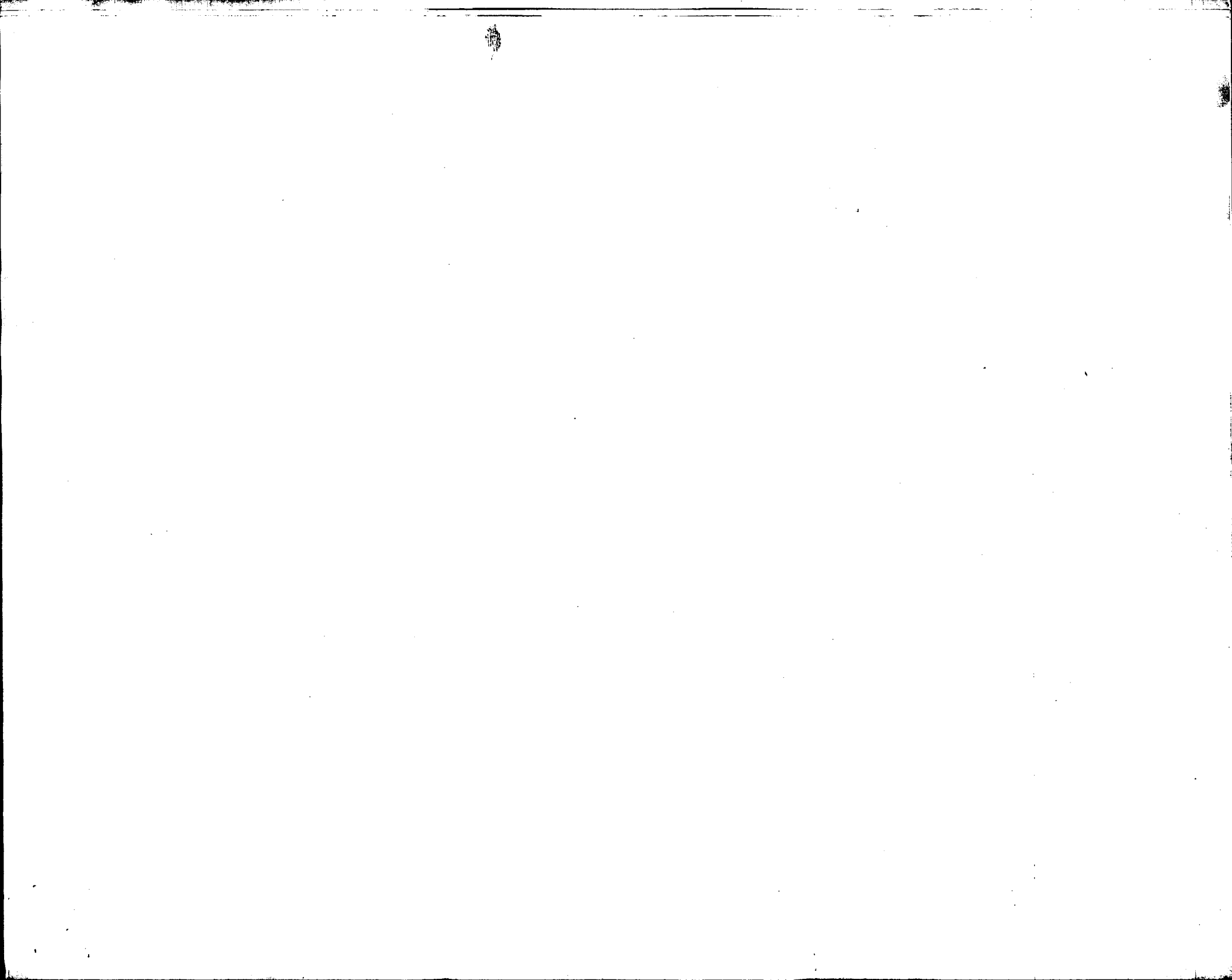
Item ID: D205-634-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube Fits LH or RH
 Start Date: 7/02/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/02/13 Req'd Qty: 2.00 *2* Customer:
 Reference: rework/repair

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105		0.00							
105						2			
HandFinish	Memo	0.00							
Hand Finishing	STEP 4 ON RS1010								
106	QC5- Inspect part completeness to step on W/O	0.00							
106									
QC	Memo	0.00							
Quality Control									
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	RE-PACKAGE								

16 13/6/64

20 13-704



Picklist Print

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Work Order ID: 103838
Parent Item: D205-634-011
Parent Item Name: Skidtube Fits LH or RH

Start Date: 7/02/13

Required Date: 7/02/13

Start Qty: 2.00

Required Qty: 2.00

D4202-1
Spacer

Manufactured No

Each 1,007.0000

12

Location

Loc Qty

Loc Code

LG	1003
96906	4
98699	87
99216	912
LG002	4
97447	4

24

13-7-4

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Shop Packet Print

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DART AEROSPACE LTD		Work Order:	
Description: Repair Scheme for Canadian D205-634-041 Skidtube (Replacing crack crossbolt spacers)			
Drawing: D2580-041		Repair Scheme:	RS1010
Part No: D205-634-041		Page:	2 of 1
Batch No:		Qty:	

Rev	Date	Change Description	Prepared	Checked	Approved
A	13.04.04	New Issue	DD		

U:\Admin\Forms\Repairschemb\A.doc

Rev. A

RA 111575 D205-634-011

Re-work

Received @ Dart June 28th, 2013
Inspected @ Dart July 2nd, 2013

CUSTOMER: CANADIAN HELICOPTERS
CUSTOMER CONTACT: CHRIS WIERINGA
SHIPPED FROM: LES CEDERS PQ, CANADA

Instructions for RA 111575 D205-634-011 B29282 & B29580 Re-work

- Tubes are here for re working same re work scheme that David Duvall had original created for the previous re work
 - Remove all cross bolt spacers in the fwd. & aft saddles and the GHW areas
 - Remove the aft cap
 - Swage in new D4202-1 per DEO D2580-E-1
 - "clean" up only area around the saddles and GHW and realodine in those locations
 - Reinstall aft cap with new sikaflex and with new AN3-5A bolts and NAS1149D0332J washers qty x 2 each of each skid tube
-
- Both tubes need the same re-work work orders
 - Were removed from aircraft C-FYZT
 - Removal tags are with the RA

Time Estimate = 10 HOURS

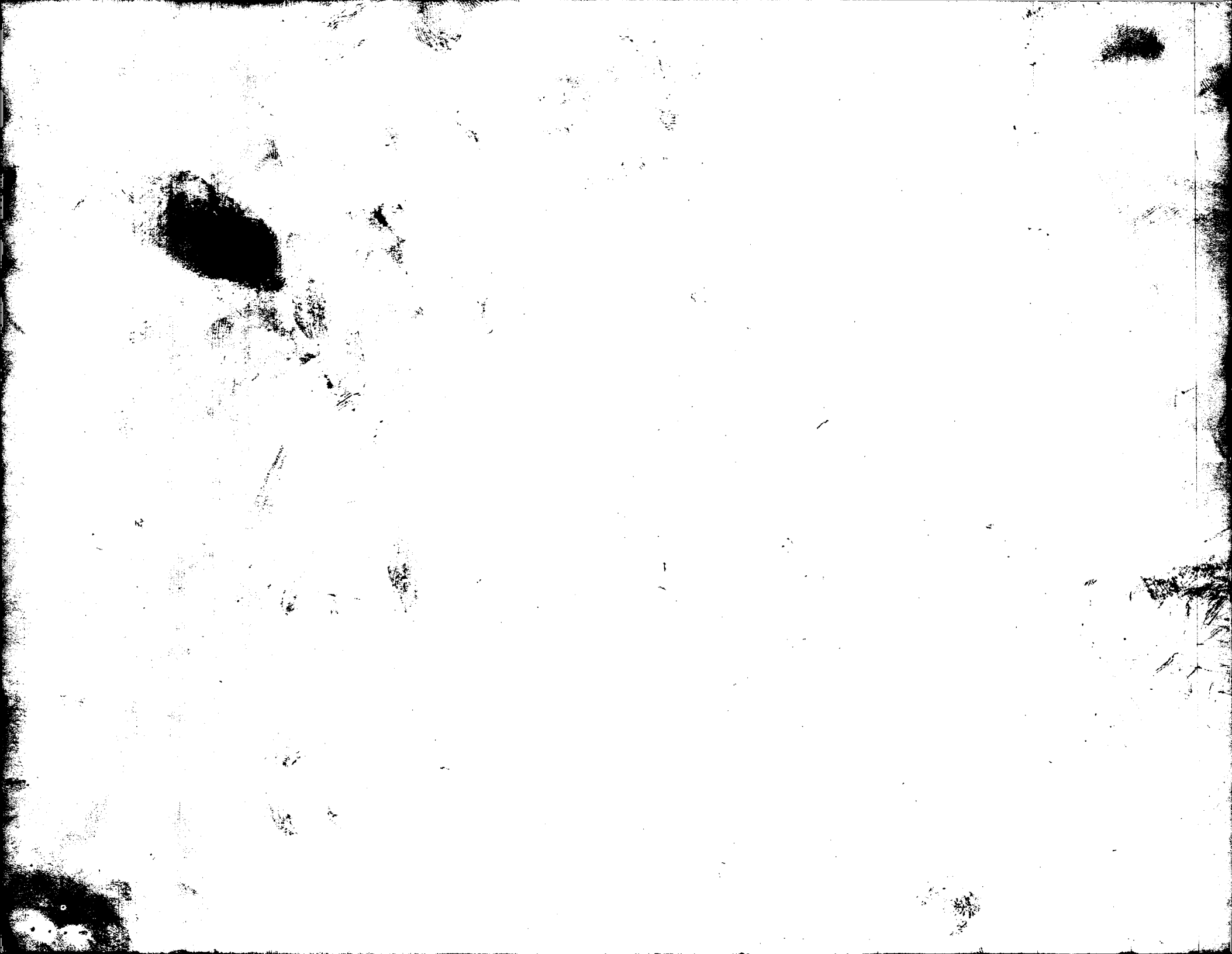
Departments Required: Stores, Landing Gear & Finishing

Pictures Attached = NO

QTY INSPECTED = x1 D205-634-011 B29282
x1 D205-634-011 B29580

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

103838



(K10003 Prop kit)

Change Record

Part Number D205-634-011 / 011DG
Description 205/212/412 SKIDSTEER

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Chg.	Date	By	Relevant Documents
001	N/A	CP	D205-634-041 CHG 001 K10003 CHG 001
002	99.04.28	CP	D205-634-041 CHG 001 K10003 CHG 002 (SADDLE SPACERS)
003	00.03.08	DS	D205-634-041 CHG 001 K10003 CHG 003 (TDW RING)
004	02.09.25	DS	D205-634-041 CHG 001 K10003 CHG 004 (SADDLES)
005	07.07.04	HA	MDL-D205-634 Rev.B
006	08.08.01	HA	MDL-D205-634 Rev.D (ECN 08-507)
007	08.12.22	HA	DS1 9417 Rev.B, D3404 Rev.C, D3405 Rev.B (ECN 08-588)
008	10.11.18	HA	DS1 9519 Rev.B, D4202 Rev.A, DEO-D2580, 2590 Rev.D (ECN 10-645)
009	11.03.31	HA	D4202 Rev.B (ECN 11-543)
010	11.12.15	HA	DEO-D2580-E-1, DEO-D2590-E-1, D4202 Rev.C, (ECN 11-684)